

Date: Monday, 7/30/2007 1:53:59 PM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: RESTRICTOR
Job Number	: 33793		
Estimate Number	: 11927		
P.O. Number	: <i>N/A</i>	Part Number	: D2005003
This Issue	: 7/30/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2005003 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i>	Drawing Revision	: E
Previous Run	: <i>N/A</i>	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 8/20/2007
Checked & Approved By	: <i>[Signature]</i> 07.07.30	Qty:	<i>33</i> Um: Each
Comment	: Est. F03.04.30 Reformat; Made on Cobra KJ/RF		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303R0500	303 Round Bar 0.500"
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Comment: Qty.: 0.0547 f(s)/Unit Total : 0.2735 f(s) *1.25'*  
303 Round Bar 0.500"  
Material: Ø1/2" AISI 303 Round Bar (M303R0.500) or Ø7/16" AISI 302/304 SS Round Tubing 0.065" wall  
(M304TR0.375W.065)  
Batch *M146292*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL  
Turn blank as per Folio FA275  
Deburr

*20 07/12/07*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*20 07/12/07*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*J.F. 07/12/07 (33)*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: *7*

*7/12/07 50 (33X)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 02/12/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: RESTRICTOR

Job Number: 33793

Part Number: D2005003

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



33

Comment: FINAL INSPECTION/W/O RELEASE

*2007/12/11*

Job Completion



*2007/12/11 CL*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

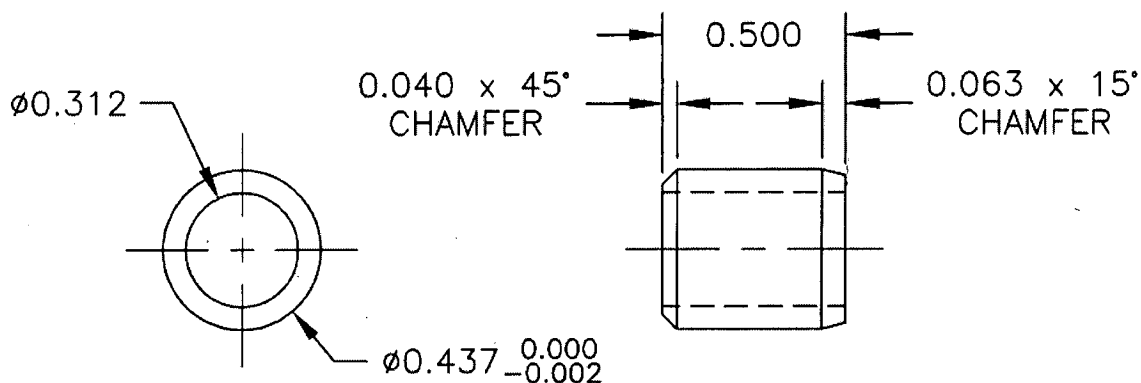
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN JB	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2005-003	REV. E SHEET 1 OF 1
DATE 03.05.01		TITLE RESTRICTOR	SCALE 2:1
C	96.04.17	REDRAWN	
D	97.09.03	304 S.S. SPEC ADDED	
E	03.05.01	ADDED TOLERANCE TO $\phi 0.437$	

RELEASED  
03.05.07 *[Signature]*



NOTE:

- 1) MATERIAL:  $\phi 0.50$  AISI 303 ROUND BAR (REF DART SPEC. M303R0.500) OR  $\phi 0.435$  AISI 302/304/316 SS 0.065 WALL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33793

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